Work Order ID 62893

Tuesday, October 12, 2010 3:12:38 PM

Item ID: D2594-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Plug, 205 Skidtube

Start Date: 10/13/2010 **Start Qty:** 80.00 **Cust Item ID:**

Required Date: 10/20/2010 **Req'd Qty:** 80.00 **Customer:**

Reference:

Approvals: **Process Plan:** MK **Date:** 10-10-12 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2594 / Rev C									
100 Hardinge — Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** 1-Make as per Dwg D2594-1 and Folio FA262.□2-Break all sharp edges 0.010 max.	0.00 0.00			10-11-1	80			
110 QC — Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00			10-11-1	80			
120 QC — Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00			B.A 10/11/01	80			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62893

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Item Name: Plug, 205 Skidtube

Start Date: 10/13/2010 **Start Qty:** 80.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00	=> M			80	0		
	Memo	0.00	10/11/01						
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				80		BK 10-11-2.	
	M115291								
	Memo	0.00							
	START TIME: 7:20 ☐OVEN TEMPERATURE: 330 ☐FINISH TIME: 7:50								
150 QC Quality Control	QC3- Inspect Part Finish	0.00	M			80	0		
	Memo	0.00	10/11/02						

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location FP-A	0.00				80	BR 10-11-2		
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00				CLW 10/11/02			
QC	**Memo**	0.00							
Quality Control									

MF
10-11-02

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 3:12:38 PM

Work Order ID: 62893

Parent Item: D2594-1

Parent Item Name: Plug, 205 Skidtube

Start Date: 10/13/2010 **Required Date:** 10/20/2010

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP D□02.08.22□Make in Cobra□KJ□
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			110	f	66.3600	0.0521	4.387368			
6061-T6 Round Bar .625"													

Location	Loc Qty	Loc Code
MAT	24	
114415	24	
MAT012	42.36	
112697	10.5	
113796	31.86	

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DART AEROSPACE LTD	Work Order:	62893
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060	✓		Vernier & 11 RQ -02	
0.500	+/-0.010	.502	✓			
Ø0.625	+/-0.010	.624	✓			
Ø0.430	+0.000/-0.002	.428	✓			
0.090	+0.000/-0.002	.089	✓			
0.045	+0.000/-0.002	.043	✓			

Measured by:		Audited by:	M.A	Prototype Approval:	N/A
Date:	10.11.1	Date:	10/11/01	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	08.07.23	Diameter symbol added	KJ/DD	

Dart Aerospace Ltd

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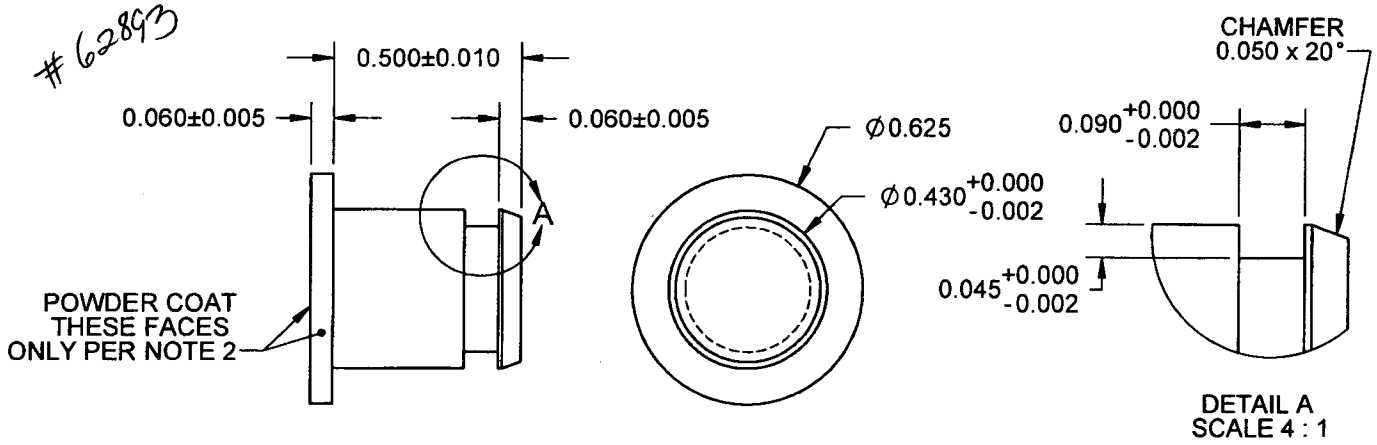
NOTE: Date & initial all entries

DESIGN	DRAWN BY CB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED	DRAWING NO. D2594 REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG	SCALE 2:1

RELEASED
06.11.28

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE

#62893



D2594-1 PLUG

D2594-1 PLUG NOTES:

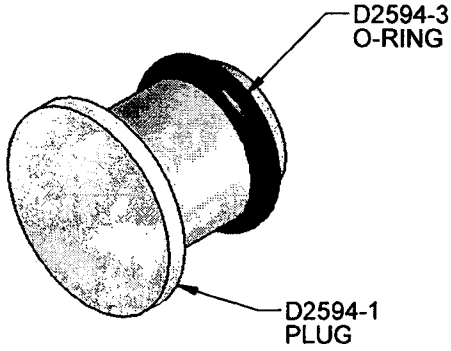
1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 (C)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

1) 5/16 ID, 7/16 OD, 1/16 WIDTH
2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 (C)

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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